

40
DART AEROSPACE LTD

Work Order:

21475

Description: 2.750 Support (407 Aft)

Part Number:

D2894-1

Dwg: D2894 Rev. B1

Qty:

7/14

Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveller. Blank size makes (2) D2894-1 Dwg not required	KJ	04.09.09	7
2	PG	Issue P/O: <i>D6104-009</i> Description: D6104-009 Material: 17-4 PH SS (AMS 5643 OR AISI 630) as per Dwg D6104 Material release note required.	KJ	04.09.09	1
3	RG	Receive and Inspect for raw material dimensions. Ensure material release note is attached.			
4	MS	Turn blank for Haas as per Folio FA253 <i>B19163</i>	KJ	04.09.09	1
5	QC1	Inspect all dimensions as per Dwg D2894	KJ	04.09.09	1
6	MV	Machine as per Folio FA253	KJ	05.08.29	14
7	MV	Tumble & Deburr	KJ	05.08.31	14
8	QC1	Inspect all dimensions to inspection sheet as per Dwg D2894	KJ	05.08.31	14
9	QC8	Inspect dimensions for second check	KJ	05.08.31	14
10	FP	Mask Ø0.500" hole prior to paint	KJ	05.08.31	14
11	FP	Powder Coat White (4.3.5.2) per QSI 005 4.3	KJ	05.08.31	14
12	QC3	Inspect Powder Coat	KJ	05.09.01	14
13	ST	Identify and stock	KJ	05.09.01	14
14	AC	Cost / part <i>131.68</i>	KJ	05.09.06	14
15	DC	Close W/O <i>29.72</i> Inspect Level 21	KJ	05.09.02	14

Rev	Date	Change	Revised By	Approved
A	02.06.06	New issue	KJ	
B	02.11.26	Added mask hole	KJ /RF	

RELEASED
02.11.29 RF

Work Order:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Manuf / Design Mgr	Approval QC Inspector

NCR		WORK ORDER NON-CONFORMANCE							
DATE	STEP	Description of NC section A	Corrective Action Section B			Sign & Date	Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial						

PAR#: N/AFault Category: N/ADQA: LJDate: 05/09/02

DART AEROSPACE LTD				Work Order:	21475
Description: Ø2.750 Support				Part Number:	D2894-1
Inspection Dwg: D2894 Rev. B1				Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2894 Rev B1/DSK079 Rev A and record below:

				Recorded Actual Dimensions						
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date	
Lathe Section										
A	2.778	2.783	Ø2.783	2.792	2.792	2.781	2.781			
B	3.990	4.010	3.999	3.999	3.999	3.999	3.999			
C	3.088	3.108	3.099	3.099	3.099	3.099	3.099			
D	0.718	0.738	0.726	0.726	0.726	0.726	0.726			
E	0.090	0.110	0.092	0.091	0.091	0.091	0.091			
F	2.968	2.988	2.978	2.978	2.978	2.978	2.978			
G	1.410	1.430	1.413	1.413	1.413	1.413	1.413			
H	1.150	1.160	1.159	1.159	1.159	1.159	1.159			
I	5.240	5.260	5.243	5.243	5.243	5.243	5.243			
J	0.022	0.042	0.022	0.032	0.032	0.032	0.032			
K	0.240	0.260	0.250	0.250	0.250	0.250	0.250			
L	0.090	0.110	0.096	0.096	0.096	0.096	0.096			
M										
HAAS Section										
AA	0.454	0.474		0.466	0.466	0.464	0.470			
AB	3.062	3.082		3.093	3.073	3.071	3.073			
AC	0.053	0.073		0.063	0.063	0.063	0.063			
AD	0.971	0.991		0.983	0.983	0.986	0.988			
AE	1.766	1.786		1.778	1.778	1.775	1.776			
AF	0.020	0.040		0.030	0.030	0.030	0.030			
AG	0.257	0.262	DT8683	0.258	0.258	0.257	0.257			
AH	0.053	0.073		0.063	0.063	0.063	0.063			
AI	3.04	3.10		3.061	3.060	3.063	3.058			
AJ	1.990	2.010		1.999	1.999	2.001	2.009			
AK	0.240	0.260		0.250	0.250	0.250	0.258			
AL	1.884	1.904		1.897	1.897	1.892	1.896			
AM	0.500	0.505	DT8708	0.500	0.500	0.500	0.500			
AN	0.189	0.194		0.189	0.190	0.188	0.188			
AO										
AP										
AQ										
AR										
AS										
AT										
AU										
Accept/Reject										

Measured by:	ER (Sor-SP) / SD	Audited by:	ER
Date:	04.10.16 / 05.08.29	Date:	05/08/30

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF RF	RF

DART AEROSPACE LTD

Work Order:

21475

Description: Ø2.750 Support

Part Number:

D2894-1

Inspection Dwg: D2894 Rev. B1

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Inspect dimensions highlighted on inspection sheet drawing D2894 Rev B1/DSK079 Rev A and record below:

				Recorded Actual Dimensions						
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date	
Lathe Section										
A	2.778	2.783		2.782	2.781	2.780				
B	3.990	4.010		3.999	3.999	3.999				
C	3.088	3.108		3.093	3.091	3.091				
D	0.718	0.738		0.721	0.723	0.725				
E	0.090	0.110		0.093	0.091	0.091				
F	2.968	2.988		2.973	2.973	2.973				
G	1.410	1.430		1.413	1.410	1.410				
H	1.150	1.160		1.157	1.153	1.153				
I	5.240	5.260		5.247	5.249	5.249				
J	0.022	0.042		0.022	0.032	0.032				
K	0.240	0.260		0.260	0.250	0.250				
L	0.090	0.110		0.096	0.091	0.091				
M										
HAAS Section										
AA	0.454	0.474		0.470	0.463	0.466				
AB	3.062	3.082		3.069	3.069	3.073				
AC	0.053	0.073		0.062	0.063	0.063				
AD	0.971	0.991		0.987	0.986	0.986				
AE	1.766	1.786		1.776	1.777	1.779				
AF	0.020	0.040		0.030	0.032	0.030				
AG	0.257	0.262	DT8683	0.257	0.257	0.257				
AH	0.053	0.073		0.063	0.063	0.063				
AI	3.04	3.10		3.060	3.055	3.056				
AJ	1.990	2.010		2.002	2.001	1.999				
AK	0.240	0.260		0.250	0.250	0.250				
AL	1.884	1.904		1.889	1.905	1.903				
AM	0.500	0.505	DT8708	0.500	0.500	0.500				
AN	0.189	0.194		0.188	0.188	0.188				
AO										
AP										
AQ										
AR										
AS										
AT										
AU										
Accept/Reject										

Measured by: *EN*
 Date: 05/08/31

Audited by: *JK*
 Date: 05/08/31

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF <i>RF</i>	<i>RF</i>

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Sep 09, 2004
03:16 pm

Work Order No : 0021475
Project Name : D2894-1
Project For : WK440
Work Order Type : Main
Main WO Number :
House Part Number : D2894-1
Description : 2.750 Support
Manufactured : Yes
Amount Req'd : 7
Amount Done : 0
Start Date : 09-09-04
Est Finish Date : 09-30-04
Act Finish Date :
Drawings Rqd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Margin : 0.000%
Actual Margin : 0.000%

\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	0.00	0.00	0.00	0.00	0.00
Engineering Hours	0.00	0.00	0.00		
Engineering Cost	0.00	0.00	0.00	0.00	0.00
Production Hours	0.00	0.00	0.00		
Production Cost	0.00	0.00	0.00	0.00	0.00
Packaging Hours	0.00	0.00	0.00		
Packaging Cost	0.00	0.00	0.00	0.00	0.00
OverHead Hours	0.00	0.00	0.00		
OverHead Cost	0.00	0.00	0.00	0.00	0.00
CNC Hours	0.00	0.00	0.00		
CNC	0.00	0.00	0.00	0.00	0.00
Misc. Hours	0.00	0.00	0.00		
Misc.	0.00	0.00	0.00	0.00	0.00
Burden	0.00	0.00	0.00		
Total Cost	0.00	0.00	0.00		
Margin	0.000	0.000			
Selling Cost	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	0.00	0.00
Profits/ (Loss)	0.00	0.00